

shp Jan. 10

Work Order ID 78103

78103

Page 1

December-28-11 3:34:09 PM

Item ID: D3964-1KGY

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Light Cover w/ Ducts

Start Date: 28/12/2011 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: M.L.J Date: 11/12/29 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3964	A

100 0.00

100

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Cut Sheet to required Blank size

x2

Ph
12/01/10

105 0.00

105

HandThermo

Dry Material

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 KYDEX

Temp: 150° F

Time IN: 7:00 pm 12/01/9

Time OUT: 5:00 am 12/01/10

x2

Ph
12/01/10

Dart Aerospace Ltd

W/O: 78103		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3964-1K64 PAR #: 12-153 Fault Category: _____ NCR: Yes ☒ No ☐ DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12.01.12 <i>[Signature]</i>	100	HOLE DIMS, Ø0.125", CHANGED SLIGHTLY. REASON: NO MARKINGS ON MOLD. DWA REQUIRES UPDATE PERMAN.	<i>[Signature]</i> 12.01.12	ACCEPTABLE. HOLES ARE TRANSFER DERIVED FROM D3964-1 TO MATING PART ON INSTALL.	<i>[Signature]</i> 12/1	<i>[Signature]</i> 12/1/12	<i>[Signature]</i> 12.01.12. OSLOFZ	<i>[Signature]</i> 12/1/12

NOTE: Date & initial all entries

Work Order ID 78103

78103

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Item ID: D3964-1KGY

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Light Cover w/ Ducts

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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110

0.00

110

Thermoform

Memo

0.00

Thermoforming Machine

1-Machine Set-Up
2-Pre-heat Tool to required temp.
3-Thermoform as per Dwg and Folio #FTA065 using tool DT9357
Dwg Rev: A
Folio Rev: B

X2

OK

12/01/10

120

QC2- Inspect parts off machine FAI/FAIB

0.00

120

QC

Memo

0.00

Quality Control

Visually inspect part for proper formation and texture

X2

OK

12/01/10

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

X2

OK

12/01/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 78103

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78103

Page 3

Item ID: D3964-1KGY

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Light Cover w/ Ducts

Start Date: 28/12/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 16/01/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

0.00

140

HandThermo

Memo

0.00

Hand Finishing Thermoforming

1-Trim to finished dimensions as per Dwg

x2

12/01/13

150

QC2- Inspect parts off machine FAI/FAIB

0.00

150

QC

Memo

0.00

Quality Control

Complete FAI document

x2

12/01/13

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.00

Quality Control

8/12/01/13

④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

December-28-11 3:34:12 PM

Page 1

Work Order ID: 78103

78103

Parent Item: D3964-1KGY

D3964-1KGY

Parent Item Name: Light Cover w/ Ducts

Start Date: 28/12/2011

Required Date: 16/01/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: New issue DD verified by:EC
Add Step 105 Dry Material 10/04/21 DL

IPP Rev B:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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MKYD6185S.080-P3-
52068

Purchased

No

sf

1,011.893

1

MKYD6185S 080-P3-52068

Kydex steel grey

**

Location

Loc Qty

Loc Code

therm

1011.893107

111807

10.4896282

119476

1001.40348

2 sq ft

12/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

11/12/29



RELEASED
09/06/25 170

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.08 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9357 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.040" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3964-1KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3964-1KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

A	NEW ISSUE	PH	09.06.22
REV.		DESCRIPTION	BY DATE
DESIGN	<i>RA</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3964 TITLE LIGHT COVER W/DUCTS (206 L3/L4) COPYRIGHT © 2009 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	REV. A
DRAWN	<i>RA</i>		SHEET 1 OF 2
CHECKED	<i>J</i>		SCALE
MFG. APPR.	<i>RA</i>		NTS
APPROVED	<i>RA</i>		
DE APPR.	<i>RA</i>		
DATE	09.06.22		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

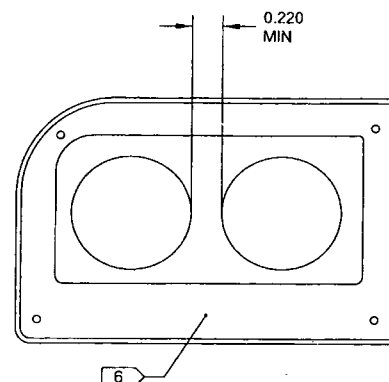
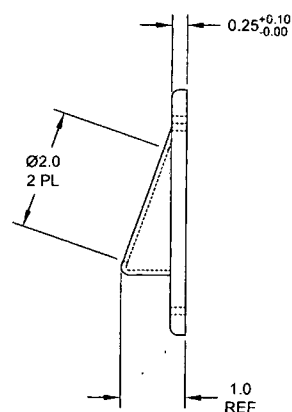
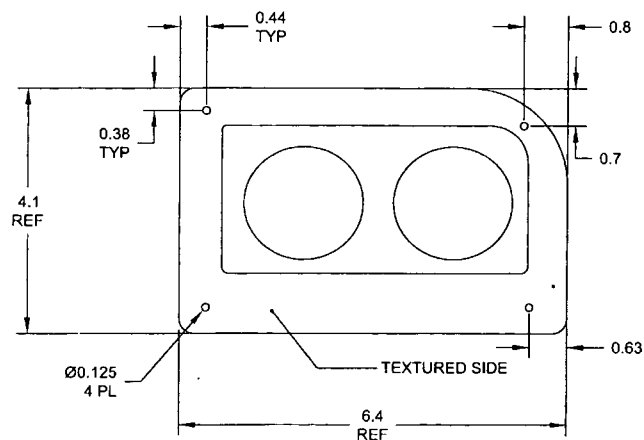
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

78103

**D3964-3 LIGHT COVER W/DUCTS****NOTES:**

- 1) MATERIAL: SEE TABLE
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N (SEE TABLE) USING VIBRATING STYLUS
- 7) WEIGHT: 0.08 lbs
- 8) TOOLING: THERMOFORM PER MOLD DT9358 PER DART QSI 022. TRIM PER MOLD
- 9) MINIMUM THICKNESS: 0.040" UNLESS OTHERWISE NOTED

PART NUMBER	DESCRIPTION
D3964-2KIV	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, IVORY #62015 (MKYD6185S.080-P3-62015)
D3964-2KGY	KYDEX 6185, 0.080 THICK, P3-VELOUR MATTE, STEEL GRAY #52068 (MKYD6185S.080-P3-52068)

DESIGN	RA
DRAWN	RA
CHECKED	RA
MFG. APPR.	RA
APPROVED	RA
DE APPR.	RA
DATE	09.06.22

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.	REV. A
D3964	SHEET 2 OF 2
TITLE	SCALE
LIGHT COVER W/DUCTS (206 L3/L4)	NTS

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RELEASED
09/06/25 WND

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order: 78103
Description:	Part Number: D3964-1K6X
Inspection Dwg: D3964 Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST
THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than 1/8"	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: Dh	Date: 12/01/10
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TRIMMING SECTION

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.4"	Ref	6.375"	✓			
4.1"	Ref	4.1"	✓			
0.730"	M.N	0.790"	✓			
2.0"	+/- 0.012"	2.008"	✓			
0.125"	+/- 0.004"	0.125"	✓			
0.75"	+/- 0.030"	0.779"	✓			
0.63"	+/- 0.030"	0.689"		✓		See NCR
0.50"	+/- 0.030"	0.492"	✓			
0.38"	+/- 0.030"	0.390"	✓			
0.75"	+/- 0.030"	0.825"		✓		See NCR

Measured by: Dh	Date: 12/01/12
Audited by: J	Date: 12/01/12
Preliminary Approval:	Date:

Rev	Date	Change	Revised by	Approved
B	10.04.14	Added preliminary approval	KJ	

10.04.14